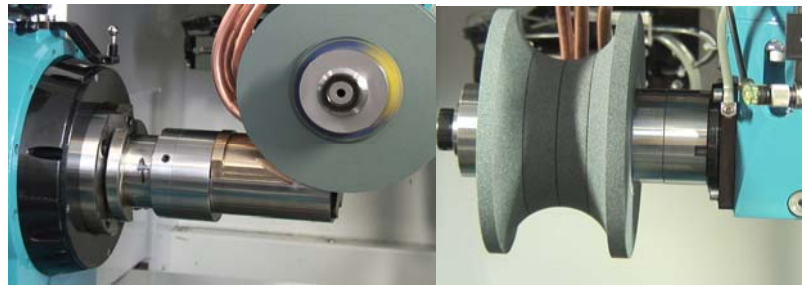


## Tool working Pipe




A30-200

The tool is produced by a solid cylinder with conventional wheels. It allows to change the spline geometry fast and economically by simply changing the wheel-DXF and redress the new geometry on the same wheel, and for small splines the wheel can be kept sharp as being redressed when needed.



### 1. Cycletime for Production

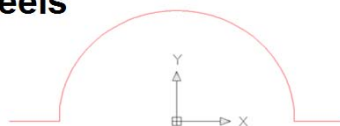
**Tool specifications**  
Diameter 139 mm, Z26, Length of cutting edge 90mm,  
depth tooth: 5.3mm, Material 18NiCrMo7-6+HH

Operations	 	
	Dress	Flute
Feed [mm/Min]	120	5
Power [kW]	1	1
Cutting feed [m/s]	32	24
Used wheels		
Grinding time [s]	120	1440
Total cycle time	26 Min 00	

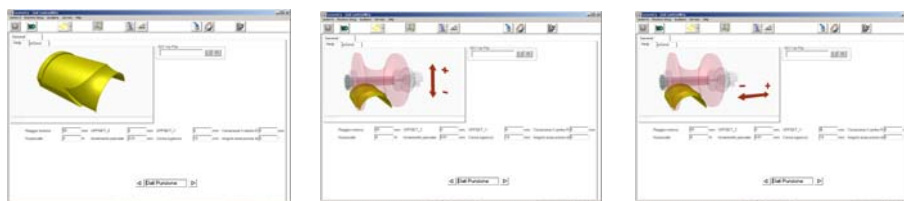
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1 Ø125 DXF Conventional



### 3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5  
Engineer: Diego Albiero, 01.04.2009

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